

Work Order ID 80093

80093

Page 1

February-09-12 4:30:10 PM

Item ID: D2975

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearshoe

Start Date: 09/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/02/10 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2975	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2975 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

1010.063

B12-3-5

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-7

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

512/03/05

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form as per dwg D2975 using DT8261 & DT8326	0.00 0.00				<u>6</u>			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>46</u>			
150 *150* Large Fab Large Fab	Large Fab Memo Weld hard surface using DT8210 as per Dwg D2975 & QSI 004Qty Description Batch A/R 7560 Hardcoat Rod <u>m117964</u>	0.00 0.00				<u>66</u>			<u>me/MAL 12-03-29</u>

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Quality Control

+
QC Memo

0.00

8/26/10

(+6)

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

7h45 FINISH TIME:

0.00

OVEN TEMPERATURE:

320°F

M117338

6 8 (28) 12/04/03

180

QC3- Inspect Part Finish

0.00

180

QC

Quality Control

Memo

0.00

6 BL 124-3

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: 500

0.00

190

Packaging

Memo

0.00

Packaging

JB (6) 12/04/03

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/4/3

12-04-3

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Picklist Print

February-09-12 4:30:14 PM

Page 1

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Parent Item: D2975

D2975

Parent Item Name: Wearshoe

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: C02.10.23Re-formatKJ

IPP Rev:D Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

76.0000

0.2758

1.741895

M1010S16GA

**

12-12-3-5

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

76

116791

21.4

117500

24.6

118965

30

17500

(6)

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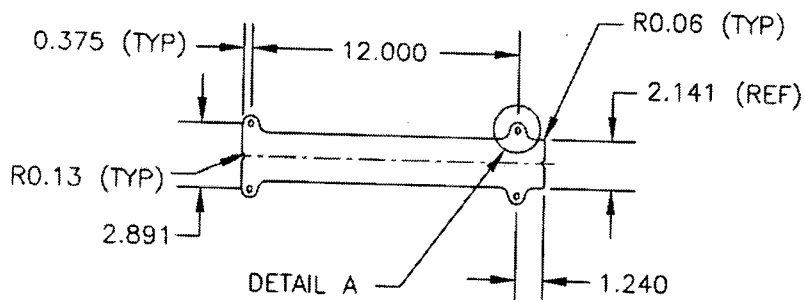
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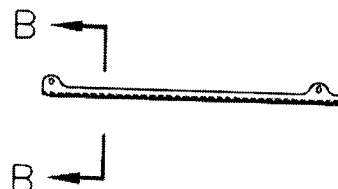


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2975	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE WEARPLATE	SCALE 1:8
A	00.03.10	NEW ISSUE	

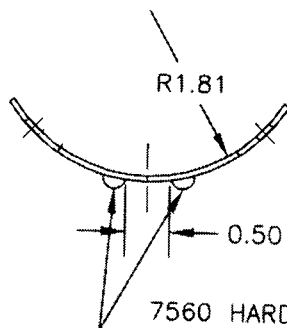
FLAT PATTERN



BENDING DETAIL



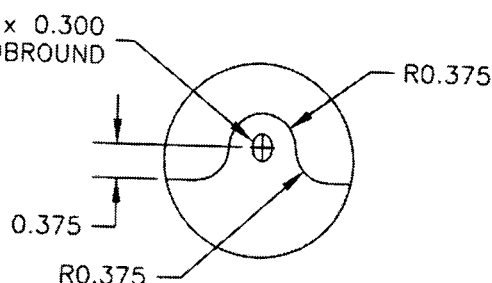
SECTION B-B SCALE 2:5



7560 HARDCOAT WELDS TO
WITHIN 0.25 OF WEARSHOE
ENDS 0.063 TO 0.125 THICK

80093 M.L.S. OBROUND
12/02/10

DETAIL A SCALE 2:5



RELEASED
00.05.11

BREAK ALL SHARP EDGES 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
16 GAUGE (0.063 THICK)
FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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